

Work Order ID 54784

December 22, 2009 9:17:53 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid 205/350

Start Date: 12/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Plan Accept Reject Reject Insp.
Rev. Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: M109213 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

SY 10/01/11

(12)

PD 10.01.12

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Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 12/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

=> S 10-1-12



130

* pressure wash
White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M 113170

=> M 10-01-14



1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 8:00AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:30AM

2ND COAT:

START TIME: 9:00AM






OVEN TEMPERATURE: 400°F



FINISH TIME: 9:30

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December 22, 2009 9:18:00 AM

Item ID: D2512 Accept  Setup Start 
Revision ID:
Item Name: Basket Lid 205/350 Stop 
Start Date: 12/22/09 Start Qty: 1.00  Cust Item ID:
Required Date: 1/04/10 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

140

0.00



HandFinishing

HandFinish

Memo

12541 SPRAY PAINT.

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

1112900

BR 10-01-15. ①.

150

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

=> 51061115

④

160

0.00



Identify as per dwg & Stock Location: _____

Packaging

Memo

USED on w/o 54782

0.00

Packaging

D350-607-041

BR 10-01-15 ①.

Work Order ID 54784

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Page 4

Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 12/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/18 *[Signature]*
MF 10-1-15

Picklist Print

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Page 1

Work Order ID: 54784

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 12/22/09

Required Date: 1/04/10

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

| | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|--------|--|--|--|
| D2012-117 | | Manufactured | No | | | 100 | Each | 14.0000 | 2.0000 | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|--------|--|--|--|



Clevis

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

31101

2

52498

12

ONLY APPLICABLE ON D130-701-041

| | | | | | | | | | | | | |
|---------|--|--------------|----|--|--|-----|------|---------|--------|--|--|--|
| D2232-1 | | Manufactured | No | | | 100 | Each | 12.0000 | 2.0000 | | | |
|---------|--|--------------|----|--|--|-----|------|---------|--------|--|--|--|



Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

48230

2

Main Warehouse

WA

10

51105

10

N/A

2x

24/10/01/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 54784

Parent Item: D2512

Parent Item Name: Basket Lid 205/350


Start Date: 12/22/09

Required Date: 1/04/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2327-1  Spacer Bushing | | Manufactured | No | | | 100 | Each | 27.0000 | 2.0000 | | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

51331

2

52832

25

2x *SH* 10/01/04

D2506



Label Plate

Manufactured No

100

Each

8.0000

1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

44275

1

Main Warehouse

WA

7

52834

1

54136

6

1x *SH* 10/01/04

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 54784

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 12/22/09

Required Date: 1/04/10

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2581 | | Manufactured | No | | | 100 | Each | 18.0000 | 2.0000 | | | |



Mounting Bracket



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

46086

2

48428

1

51120

9

Main Warehouse

WA

6

50872

1

51745

5

2x *[Signature]* 10/01/09

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Picklist Print

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Page 4

Work Order ID: 54784

Parent Item: D2512

Parent Item Name: Basket Lid 205/350


Comments:

Start Date: 12/22/09

Required Date: 1/04/10

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|--|--------|
| D3166-3  Basket Hoop | | Manufactured | No | | | 100 | Each | 17.2593 | 1.0000 | | 10-01-09 SAD 09 10-01-09 | |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| 53494 | 5.267175 | |
| 53494 | 5.267175 | 1 |
| Main Warehouse | | |
| ST | 5.75 | |
| 44997 | 0.01 | |
| 47957 | 0.74 | |
| 48429 | 5 | |
| Main Warehouse | | |
| WA | 6.242114474 | |
| 50033 | 0.0527 | |
| 50618 | 0.1894 | |
| 52058 | 1.4474E-05 | |
| 54018 | 6 | |

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Shop Packet Print

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Picklist Print

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Work Order ID: 54784

Parent Item: D2512

Parent Item Name: Basket Lid 205/350


Comments:

Start Date: 12/22/09

Required Date: 1/04/10

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304EX0.75-16F | | Purchased | No | | | 100 | sf | 402.0569 | 18.9474 | | | |
|  | | | | | | | | | | | | |
| Expanded Metal Flat SS | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

402.0569065

110134

3.4

111956

0.000017

112147

9.4736E-06

112949

61.74758

113205

16.9093

113497

320

SAD ~~10-01-11~~

18.9474

M304TS0.750W.065

Purchased

No

100

f

390.8178

45.8741



304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

390.8177742

113082

0.00419

113245

390.813584

Main Warehouse

WA

0.0000047

112398

0.0000047

SAD ~~10-01-09~~

45.8741

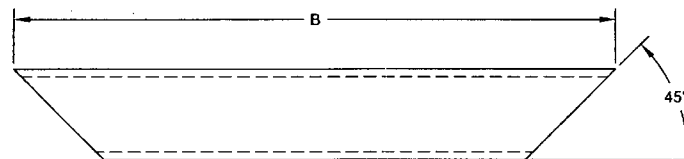
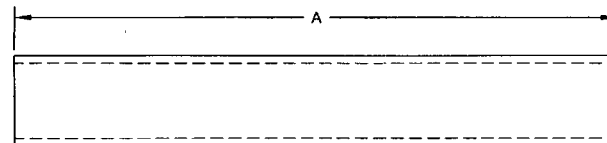
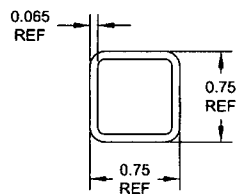
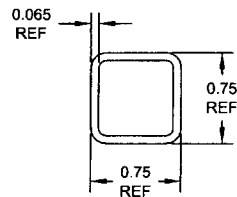
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Shop Packet Print

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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

| PART NO | QUANTITY | LENGTH A | LENGTH B | DESCRIPTION |
|---------|----------|-------------|-------------|------------------|
| D2512-1 | 2 | — | 25.50 | RIB |
| D2512-3 | 2 | — | 95.30 | RIB |
| D2512-5 | 6 | 30.84 | — | RIB |
| D2512-7 | 3 | 30.63 | — | RIB |
| D2232-1 | 2 | N/A | N/A | HINGE PLATE |
| D2236 | 4 | N/A | N/A | RIB |
| D2327-1 | 2 | N/A | N/A | BUSHING |
| D2506 | 1 | N/A | N/A | LABEL PLATE |
| D2581 | 2 | N/A | N/A | MOUNTING BRACKET |



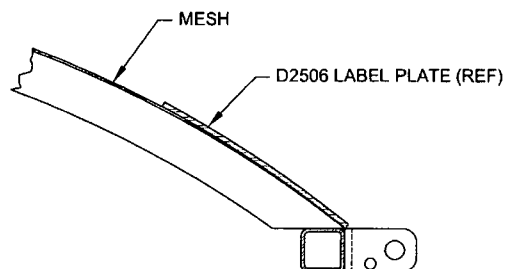
*W/O
54784*

RELEASED
08-08-21/118

| | | | |
|------------|--|---|--------------|
| E | INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED. | AJS | 08.06.17 |
| D | CHANGE HINGE | CP | 01.04.19 |
| C | REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074 | DS | 99.07.06 |
| B | ADDED LATCH CHANNEL & LABEL PLATE | BW | 96.05.24 |
| A | NEW ISSUE | BW | 95.11.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | <i>[Signature]</i> | D2512 | SHEET 1 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | BASKET LID ASSEMBLY (350/212) | NTS |
| DATE | 08.06.17 | <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

D2512-1/-3/-5/-7 NOTES:

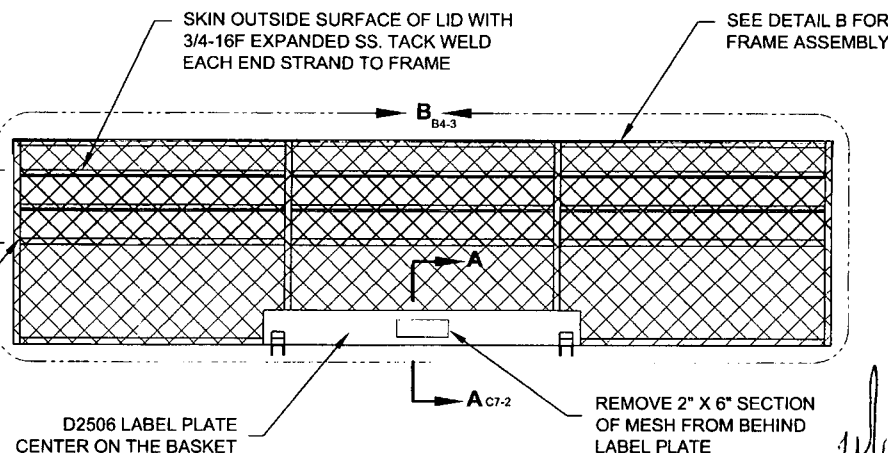
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST



SECTION A-A^{B3-2}
(ROTATED 90° CCW)

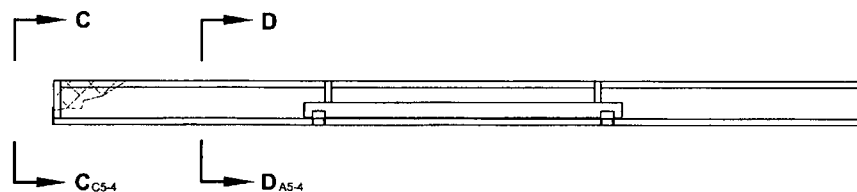
FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED







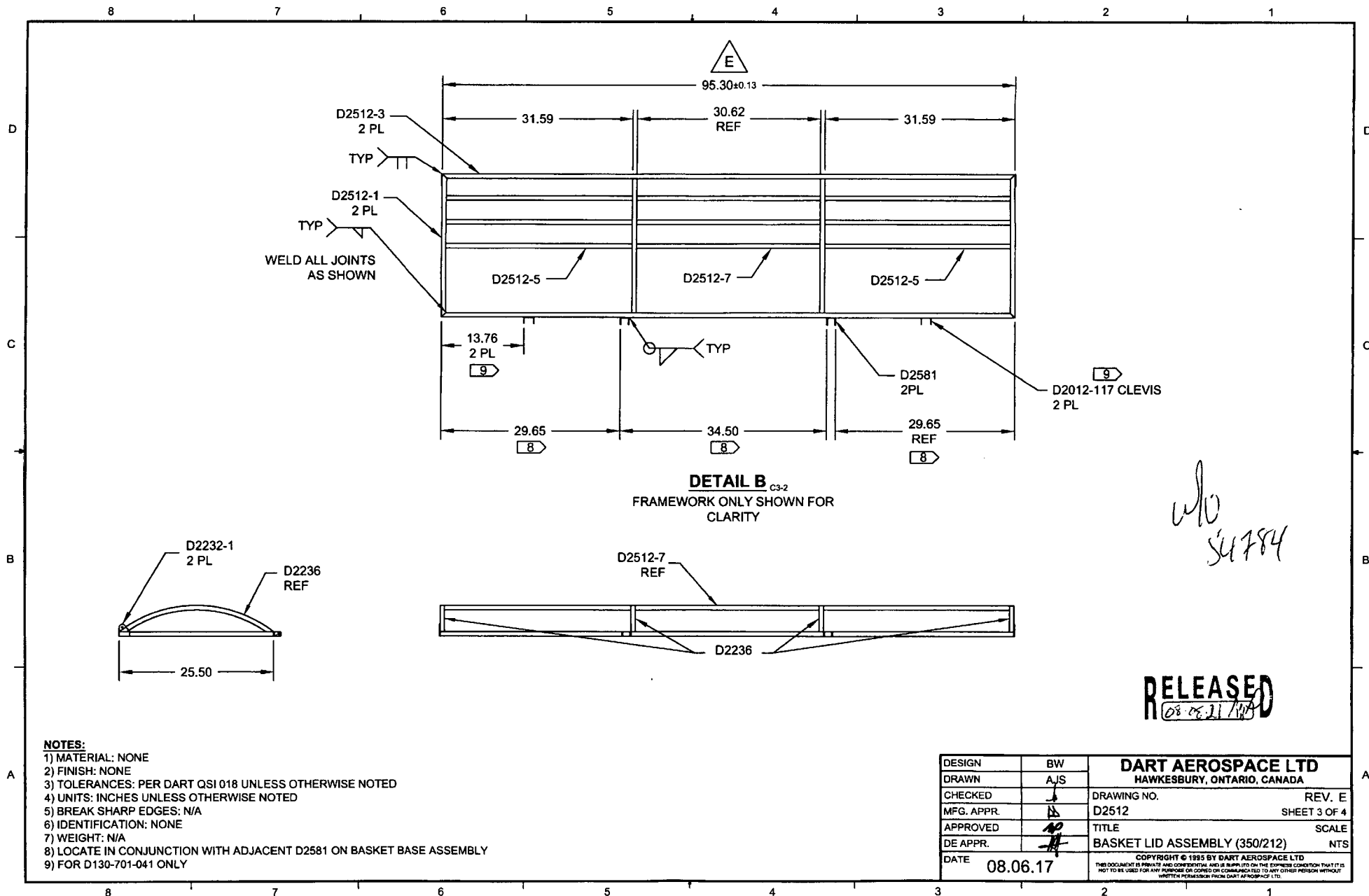
D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



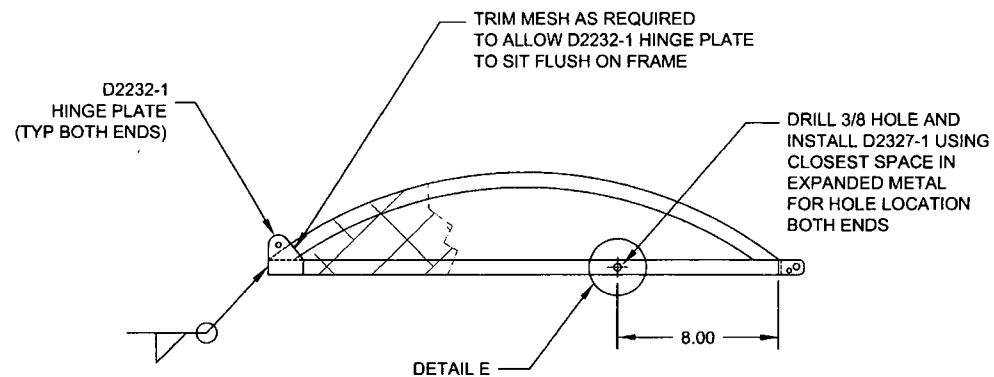
RELEASED
08.06.17

| | | | |
|--|---|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. E |
| MFG. APPR. |  | D2512 | SHEET 2 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | BASKET LID ASSEMBLY (350/212) | NTS |
| DATE | 08.06.17 | COPYRIGHT © 1995 BY DART AEROSPACE LTD | |
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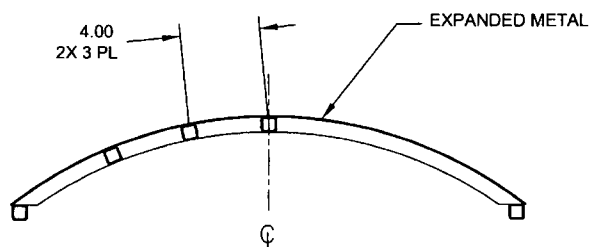


| | | | |
|------------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | J | DRAWING NO. | REV. E |
| MFG. APPR. | H | D2512 | SHEET 3 OF 4 |
| APPROVED | H | TITLE | SCALE |
| DE APPR. | H | BASKET LID ASSEMBLY (350/212) | NTS |
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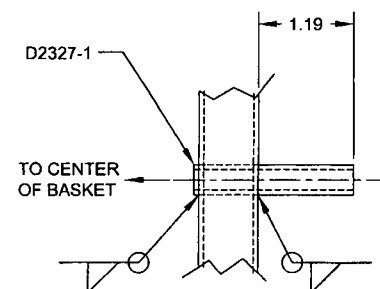
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2







SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

41054784

RELEASED
08-06-21/140

| | | | |
|---|---|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. E |
| MFG. APPR. |  | D2512 | SHEET 4 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | BASKET LID ASSEMBLY (350/212) | NTS |
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8 7 6 5 4 3 2 1